

Work Order ID 86424

June-28-12 1:01:14 PM

86424

Page 1

Item ID: D2938-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle RH Out, 206

Start Date: 28/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M65 Date: 12/06/20 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

12/07/10 10 0

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

12-07-12 (x10)

120

QC1- Inspect dimensions to dimension sheet

0.00

120

QC

Memo

0.00

Quality Control

12/07/10 10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 8:30	OVEN TEMPERATURE:							
	FINISH TIME: 3200F	9:00							

M121841

DAS 14 12/07/18

10 0

10 76 12-7-18

10X 4 M/L 12/07/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

10x 4 11/07/18

170

Identify as per dwg & Stock Location: ST428a 0.00***170***

Packaging

Memo

0.00

Packaging

(10x) 12/7/18

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

12/7/18

ME
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-28-12 1:01:17 PM

Page 1

Work Order ID: 86424

86424

Parent Item: D2938-2

D2938-2

Parent Item Name: Saddle RH Out, 206

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	89.0000	1	4			
D6101-003									**	10		<i>12/07/15</i>	
Saddle Billet, 7075													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	49	
73775	2	
73780	7	
78599	10	
80765	0	
85434	23	
MAT042	39	
81924	46	10
MAT044	1	
73769	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26424
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.108	.108	.108	.107		
B	0.100	0.140		.107	.109	.105	.105		
C	0.100	0.140		.119	.118	.118	.116		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.248	1.248	1.248	1.248		
F	1.245	1.255		1.248	1.248	1.248	1.248		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.5755	1.579	1.579	1.579		
J	2.495	2.505		2.4985	2.499	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.118	.120	.119		
O	0.540	0.560		.547	.546	.546	.548		
P	0.490	0.510		.501	.496	.498	.5025		
Q	3.715	3.725		3.720	3.716	3.716	3.717		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.254	.255	.252	.252		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.6295	1.629	1.629	1.629		
V	1.362	1.372		1.368	1.368	1.368	1.369		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.2586	1.255	1.258	1.258		
Y	1.565	1.585		1.5737	1.570	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	ff
Date:	12/07/15

Audited by:	DAS 14
Date:	12/10/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action-Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86424
Description: 206 Saddle, Outboard, Right side		Part Number: D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.100	0.140		.109	.108	.113	.109		
B	0.100	0.140		.102	.101	.102	.106		
C	0.100	0.140		.118	.118	.117	.118		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.580	1.579	1.579		
J	2.495	2.505		2.500	2.500	2.500	2.504		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.119	.121	.118		
O	0.540	0.560		.549	.5475	.546	.546		
P	0.490	0.510		.503	.502	.502	.502		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.250	.250	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.628	1.629		
V	1.362	1.372		1.3665	1.368	1.368	1.368		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.261	1.261	1.261	1.259		
Y	1.565	1.585		1.577	1.577	1.577	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>ST</i>
Date: 12/07/16

Audited by: <i>DAS</i>
Date: 12/07/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	86424
Description: 206 Saddle, Outboard, Right side		Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1	

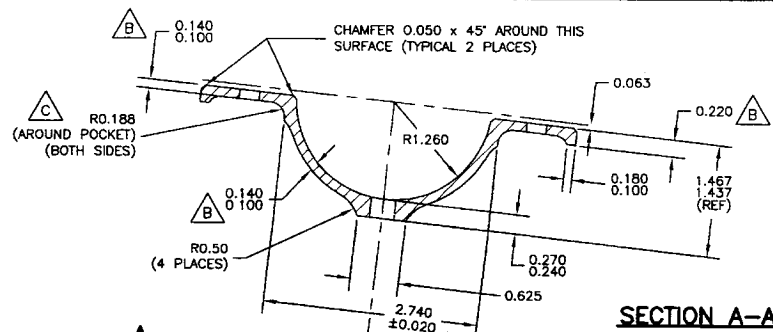
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9/	10/	3	4	By	Date
A	0.100	0.140		.113	.114				
B	0.100	0.140		.107	.107				
C	0.100	0.140		.122	.122				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.499	2.499				
H	0.510	0.515		.500	.500				
I	1.572	1.582		1.578	1.579				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.116	.119				
O	0.540	0.560		.5465	.547				
P	0.490	0.510		.504	.501				
Q	3.715	3.725		3.718	3.718				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.251	.252				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.629	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.257	1.259				
Y	1.565	1.585		1.574	1.574				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

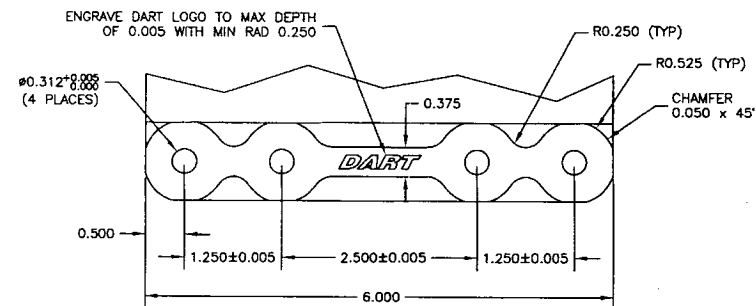
Measured by:	<i>St</i>
Date:	12/07/16

Audited by:	DAS
Date:	12/07/18 ¹⁴

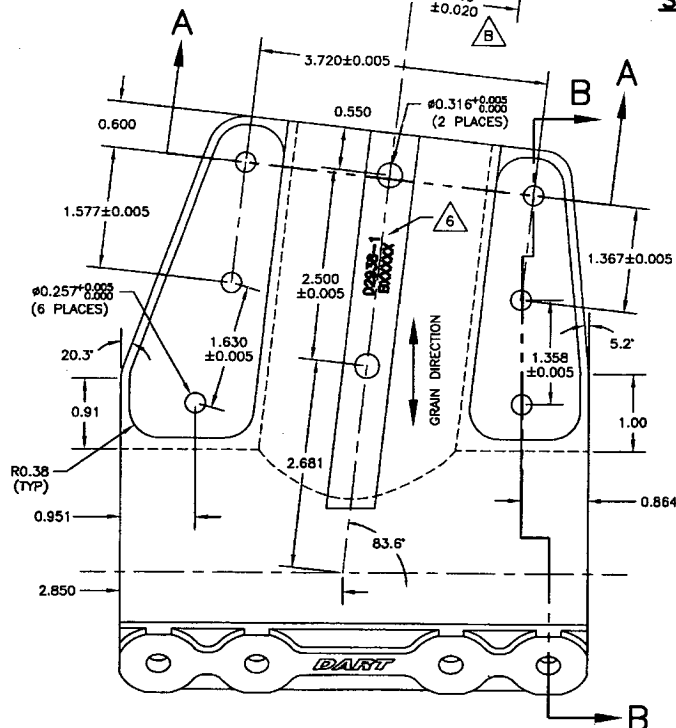
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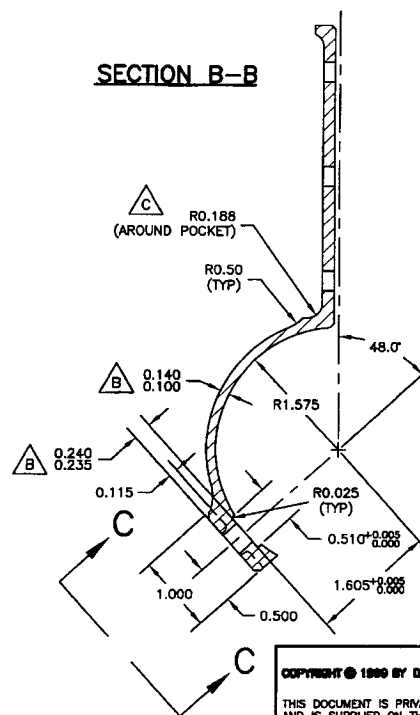
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE OUTSIDE
		DRAWING NO. D2938
		REV. C SHEET 1 OF 1
		SCALE 2:3

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26424 MLC
12/06/28

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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